

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001685**Date Inspected:** 04-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Zhi Jiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Caltrans Quality Assurance Inspector Gabriel Quintana (QA Inspector) arrived at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to observe fabrication and Quality Control Inspectors (QC Inspectors) perform their duties and responsibilities as specified in the contract documents, approved plans, fabrications documents and Special Provisions for this project. While on site the QA Inspector observed the following:

Bay 7- QA Inspector randomly observed ZPMC qualified welder Wang Linjiang Identification (ID) #051356, utilizing the Flux Core Arc Welding (FCAW) process per the approved Welding Procedure Specification (WPS) WPS-B-T-2132-3 while performing welding on Floor Beams FB003-006 at weld joint FB003-006-005. The QA Inspector observed ZPMC Certified Weld Inspector (CWI) Li Zhi Jiang monitoring welding and preheating parameters. The QA Inspector also randomly monitored weld parameters and recorded them as follows: welding amperage 303 amps, welding voltage 29.4 volts. The weld parameters appeared to comply with contract requirements and the approved WPS.

OBG Yard- Caltrans QA Inspector performed an Ultrasonic Test (UT) inspection of the partial joint penetration (PJP) welds between the closed u-ribs and deck panel of DP058-001. UT inspection was performed at 100% of the tack welded locations on welds DP058-001-001, DP058-001-002 and DP058-001-005. QA Inspector observed that the tack welded locations of welds DP058-001-006 thru DP058-001-010 were UT inspected by Caltrans QA Inspector Alfredo Acuna and welds DP058-001-003 and DP001-004 were inspected by Caltrans QA Inspector Greg Bertlesman. QA Inspector recorded the results of the inspection and generated an ultrasonic test report. See ultrasonic testing report TL-6027 Modified dated March 04, 2008 for more details.

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Summary of Conversations:

General conversations took place between the QA and QC Inspector.



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Quintana, Gabriel	Quality Assurance Inspector
Reviewed By:	Hager, Craig	QA Reviewer
